

ASAP

Work Order ID 55027



January 5, 2010 1:19:36 PM

Item ID: D1048

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle

Start Date: 05/01/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: 10-1-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D1048	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 063

1-Cut as per Dwg D1048

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

→ SAD 10-01-12 (29)

may not pull

HB 10-1-7



29

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-1-7

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 501013

winter



4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

m-f 10/01/15

29X

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per dwg D2010 using DT8053

m-f 10/01/15

29X

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

250606/15

counter
125

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref 4.3.5.7) per QS1005 4.3

11109091

0.00

=> H1

10/01/18

(X29) 9

Memo

START TIME: 2:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:30pm

0.00

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

10-01-18

(29) 9

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: 10

Memo

0.00

0.00

10-1-18

(29x) SP

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Approvals:

Process Plan:

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Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

60/01/19 *AF*

MF 10-1-19

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Picklist Print

January 5, 2010 1:19:40 PM

Page 1

Work Order ID: 55027

Parent Item: D1048

Parent Item Name: Saddle

Comments:

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Rate Issued	Status
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M304S16GA

Purchased

No

100

sf

370.2779

0.3789

16



1810-1-7

304/316 Sheet .063

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

370.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

307.1895

112290

112290



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RELEASED
17/07/02 R

NOTES:

1) MATERIAL

STAINLESS STEEL

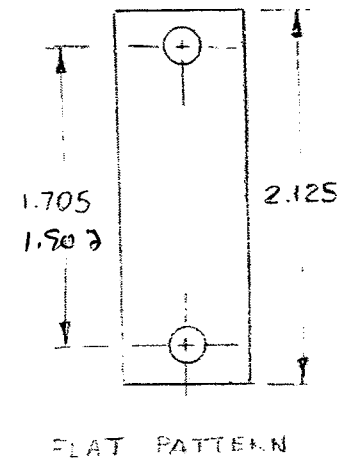
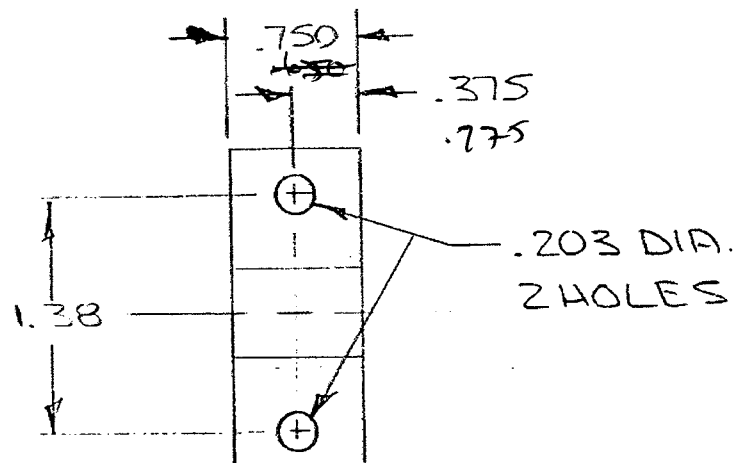
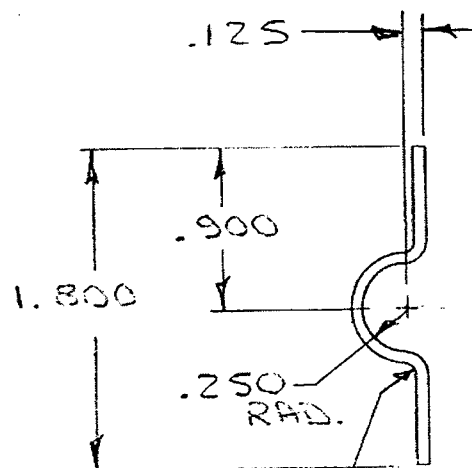
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QCI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55027

PL 10-1-05



.063 RAD
(TYP)



A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR		
	RF		DRAWN	BASIC CODE	DIA. ENDIC. RCL. 6H-HEAD NEAR SIDE P-HEAD FAR SIDE	CONTRACT NO.	DART DART AERO ACCESSORIES INC. CANADA				
			APPROVED	D-DIMPLE D-DIMPLE D-DIMPLE	LENGTH DIM. IN IN. WH. DIM. IN IN.	DRAWN BRADLEY	DATE 5/1/91	TITLE CLAMP			
			DESCRIPTION OF CHANGE	BASIC CODES B-M-230476AD B-M-230476AD		DESIGN BRADLEY	STRESS	CHECKED	CLIENT	COOK	DWG NO. D1048
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		REPORT ALL DISCREPANCIES — DO NOT SCALE		SCALE 1:1 SHT 1 OF 1							

D1048

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